Data

Lateral runout on ring gear	max. 0.4
Centering flange dia. for ring gear	268.31–268.39
Shrink-on temperature	220 °C
Annealing color	yellow

Conventional accessory

Temperature measuring chalk	e.g. from AW Faber-Castell D-8504 Stein bei Nürnberg color no. 2815/220 (white) Thermochrom

Note

The ring gear is hardened. To protect hardness, the temperature for hardening ring gear should not exceed 220 °C at any point. This can be done reliably only by means of a hot plate or a heating oven.

An open flame may be used as an exception only. The flame should touch only the inside of the ring gear.

Following renewal of a ring gear, the flywheel need not be balanced.

Renewal

1 Center drill old ring gear and break up with a chisel or heat quickly and immediately remove.

2 Clean mounting surface of ring gear on flywheel.

3 Uniformly heat new ring gear on a hot plate or in a heating oven.

For this purpose, use temperature measuring chalk in accordance with instructions whenever possible.

4 Mount heated ring gear immediately on flywheel.

Attention!
The tooth chamfer (arrow) should face starter motor.

As a spare part, ring gears are available with chamfered teeth only.